

Date: Tuesday, 12/12/2006 10:31:38 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 29898	
Estimate Number : 11147	
P.O. Number : <i>N/A</i>	Part Number : D3209041
This Issue : 12/12/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3209 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>J.F. 06/12/17</i>	Due Date : 1/10/2007 Qty: 6 Um: Each
Checked & Approved By : <i>J.F. 06/12/17</i>	
Comment : Est A04.06.09 New issue KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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Comment: Qty.: 0.1838 f(s)/Unit Total : 1.1025 f(s)  
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)  
 (M6061T6B1.500x01.250)  
 Identify for D3209-1  
 Batch: *M 101694* *J.F. 06/12/17* (6)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000) *J.F. 06/12/17* (6)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine D3209-1 as per Folio FA345 and Dwg D3209  
 Identify as D3209-1  
 Deburr and Tumble *J.F. 06/12/18* (6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE *J.F. 06/12/18* (6)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK *J.G. 06/12/18* (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/12

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/12/2006 10:31:39 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29898

Part Number: D3209041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(6x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M. E. / y*

*06/12/27*

7.0

POWDER COATING

POWDER COATING



(6x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the hole for D3209-1 before powder coat.

*m. E. / a.m*

*07/01/03*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*m. E. / 07/01/11*

9.0

D32093

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D3209-3	Bushing	

*B22081 x1*  
*B29907 x5*

Press fit bushing into the bracket as per Dwg D3209

*m. E. / 07/01/11*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/01/11 (6)*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *2416*

*07/01/12 (6)*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

*07/01/12*

Job Completion



*U 07-01-12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

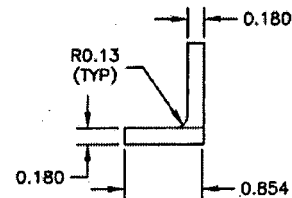
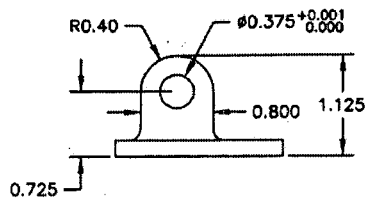
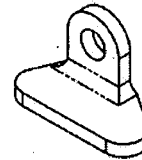
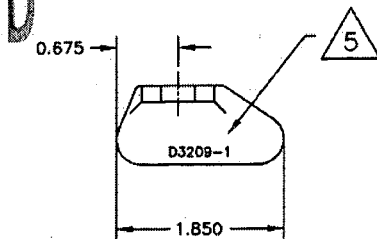
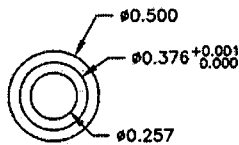
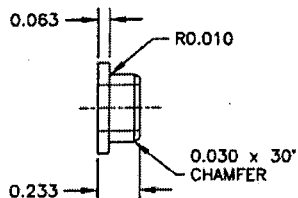
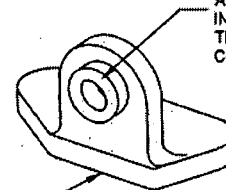
NOTE: Date & initial all entries



**DART**

DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JF	APPROVED JF	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27	TITLE BRACKET	SCALE 1:2	
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05 JF

**D3209-1 BRACKET****D3209-3 BUSHING  
SCALE 1:2****D3209-041 ASSEMBLY**

D3209-3 BUSHING  
PRESS FIT, HEAD  
AT THIS FACE  
INSTALL AFTER  
THE CONVERSION  
COAT

**D3209-1 BRACKET: D3209-3 BUSHING**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/B OR QQ-A-250/11 OR QQ-A-225/B)  
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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